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✓ **D3211-1**
Job Sheet 190752



Part No: D3211-1

Job Qty: 12 pcs

Part Name: Bracket For Interior Window For -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now on Waterjet 06-10-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		3/22/19	0.00	2.58	Waterjet - Flow		JRB 7/8/19
120	QC 8	12 pcs		3/22/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		DAS 40
							QC 8 - 67		9-89
							QC 8 - 1 (A)		
							QC 8 - 47		
130	Small Fab - 2 - B4B	12 pcs		3/22/19	0.00	0.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
140	Small Fab - Brake NC - B4B	12 pcs		3/22/19	0.04	1.60	Small Fab - Brake - 1 - B4B		DAS 30 JUL 08 2019

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				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150	QC 5	12 pcs	3/22/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
160	Handfinish - 1-1 Chemical-B4B	12 pcs	3/22/19	0.00 0.64	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
170	Powdercoat - 4 Black Sand - B4B	12 pcs	3/22/19	0.00 0.38	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
180	QC 3	12 pcs	3/22/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15

DAS
40
9-89

JUL 09 2019

JUL 10 2019

M 138940.

START: 1:20 OUT: 3:20 FINISH: 1:50

BL 19-7-10.

				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	JUL 10 2019
				QC 3 - 68	
				QC 3 - 9	
190	Packaging 3-1 - Stock - B4B	12 pcs	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					→ Packaging 3 - 3 - B4B <i>OK</i> Bin: ST438✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
200	QC 21 - SA	12 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - 1-Cut as per Dwg D3211 Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Small Fab) Deburr 140 - (Form as per dwg) Bend D3211-1 Stack as per Dwg D3211 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Chemical Conversion Coat per QSI005 4.1)					

170 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____

180 - (QC3- Inspect Part Finish)

190 - (Identify as per dwg & Stock Location:_____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	16.8600 sf (1.405 ea)	100-Waterjet - Flow - 1	5165803 x 6 5180490 x 4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	17	66	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.250inches $\pm$ 0.030	0.280 0.220		
2	Bracket	1.910inches $\pm$ 0.030	1.940 1.880		
3	Bracket	0.128inches + 0.005 - 0.000	0.133 0.128	0.130	
4	Bracket	0.141inches + 0.005 - 0.000	0.146 0.141	0.143	
5	Bracket	17.710inches $\pm$ 0.030	17.740 17.680		
6	Bracket	1.910inches $\pm$ 0.030	1.940 1.880		
7	Bracket	1.560inches $\pm$ 0.030	1.590 1.530		
8	Bracket	11.320inches $\pm$ 0.030	11.350 11.290		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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DART
AEROSPACE



Container No: S196469

Part: D3211-1
Job No: 190752
Serial No/Batch: S196469
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 07/08/19